

Date: Monday, 10/11/2008 3:34:42 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: RH ACTUATOR ASSEMBLY		
Job Number	: 43287			Part Number	: 41232 200 001 002		
Estimate Number	: 12770			Drawing Number	: 41232-200-001 REV IR		
P.O. Number	:			Project Number	: N/A		
This Issue	: 10/11/2008	S.O. No.	:	Drawing Revision	: IR		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 28/11/2008		
Previous Run	: 42219			Qty:	2	Um:	Each
Written By	:						
Checked & Approved By	: JJD 08.11.11						
Comment	: Est Rev:A New Issue 07-02-28 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	Barcode
1.0	MS208224	elbow	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) elbow Batch: M110363	9/1/09 50
2.0	AN8424D	Elbow	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Elbow Batch: M110363	8/08/12/02 (x2)
3.0	41232 200 007 001	Brass Cylinder Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Brass Cylinder Assembly Batch: 39219-1	8/08/12/02 (x2)
4.0	41232 200 003 001	Spring (Step Actuator)	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Spring (Step Actuator) Batch: 30941	8/08/12/02 (x2)
5.0	MS1699623	cap screw	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) cap screw Batch: M103934	8/08/12/01 (x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 AN3154R

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Batch: M17566

SS 08/12/01 (2)

7.0 AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

Batch: M109249

SS 08/12/01 (2)

8.0 AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

Batch: M109061

SS 08/12/01 (2)

9.0 MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Batch: M109031

SS 08/12/01 (2)

10.0 AN322A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: M106043

SS 08/12/01 (2)

11.0 41232 200 005 003

Spacer (Step Actuator)



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Spacer (Step Actuator)

Batch: B43732

SS 08/12/01 (2)

12.0 41232 200 002 005

pivot arm



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

pivot arm

Batch: 31778

① B43305

① 9/1/09

SG

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Seq. #: Machine Or Operation:

Description :

13.0 41232 200 002 003

latch



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

latch

Batch:

BR39216 x1 B43303 x1

18 08/12/18

18 08/12/01 (x2)

14.0 41232 200 002 001

tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

tube

Batch:

B43303

18 08/12/01 (x2)

15.0 41232 200 008 001

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Decal

Batch:

31023

18 08/12/01 (x2)

16.0 S 1455

spring-step actuator (replaces 71459)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

spring-step actuator (replaces 71459)

BATCH:

104079

18 08/12/01 (x2)

17.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg 41232-200-001

JF 09/01/29

(2)

2-Torque as per Dwg 41232-200-001

18.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/02 (x2)

19.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PP 43268

Jg. 3/02 (2)

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Seq. #: Machine Or Operation:

Description :

20.0 QC21

FINAL INSPECTION/W/O RELEASE



09/02/03 JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 09.02.03

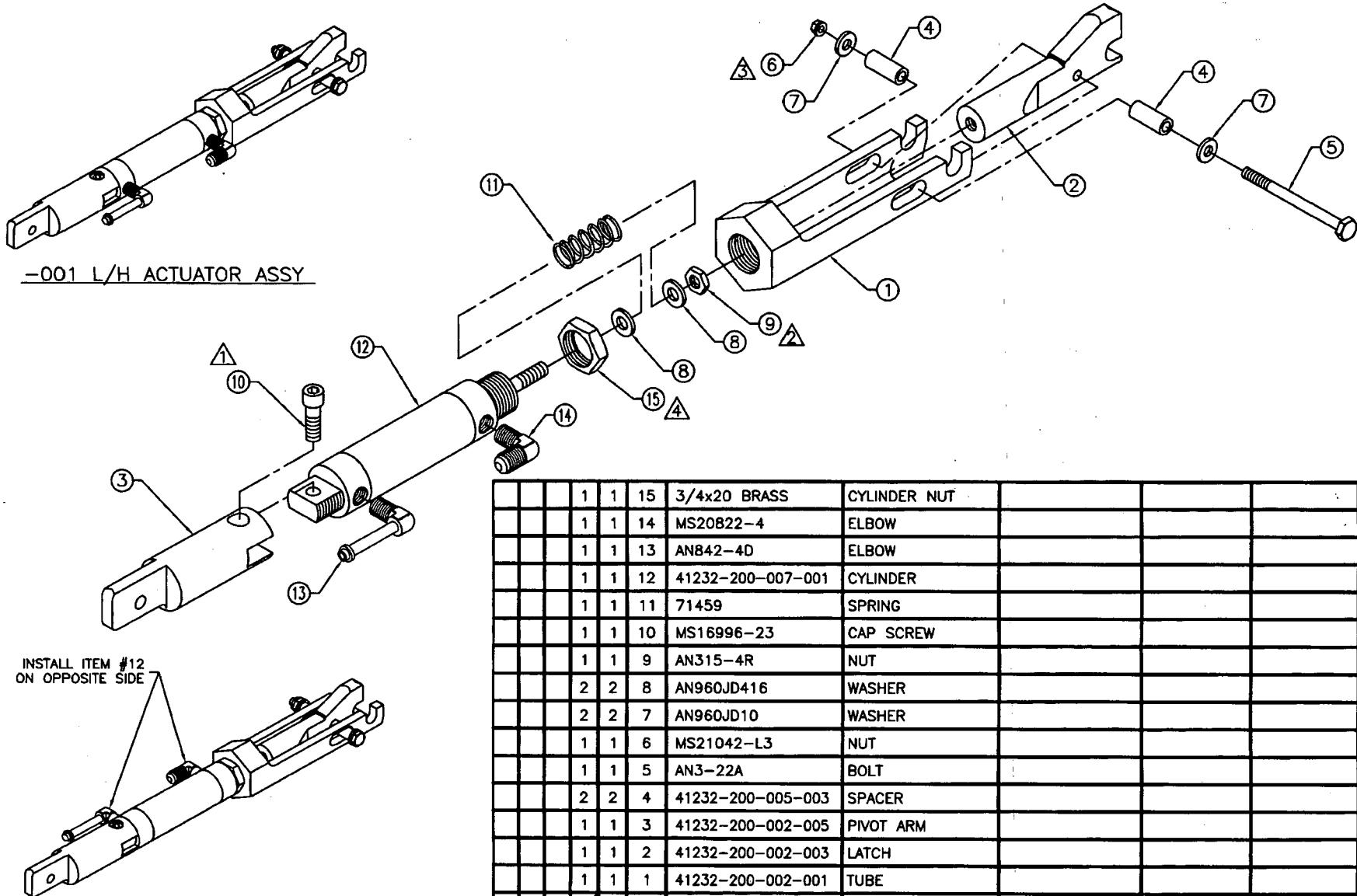
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TORQUE 80-100 IN.-LB.
TORQUE 20-25 IN.-LB.
TORQUE 50-75 IN.-LB.
TORQUE 50-75 IN.-LB.

NOTES:

ASSY
43281
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. REQ'D PER ASSY		PART NO.		NAME		STOCK SIZE		MATERIAL		MATE SPEC		ZONE	
LIST OF MATERIAL													
PROPRIETARY RIGHTS NOTICE				UNLESS OTHERWISE SPECIFIED	DRAFTSMAN		D. NELSON		5/20/02		TITLE		
					CHECK		D. MURPHY		5/20/02		STEP ACTUATOR ASSY		
THESE DATA ARE PROPRIETARY OF ERA AVIATION, INC. DISCLOSURE, REPRO- DUCTION, OR USE OF THESE DATA FOR ANY PURPOSE IS FORBID- DEN WITHOUT THE WRITTEN AUTHORITY ERA AVIATION, INC. THESE DATA DO NOT APPLY TO VENTURE PARTS.			X±.1	STRESS									
			XL±.03	PROJ. ENGR				DWG. SIZE		C		SCALE	
			XOKL±.010	HEAT TREAT								NONE	
			ANGLES ±1/2"	FINISH		Era Aviation, Inc.						DWG. NO.	
002	001	1	41232-000-001									41232-200-001	REV. IR
DRAWN BY DRAFT PAPER ARMY		NEXT ASSEMBLY			MATERIAL								

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